



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

POSITIVE RECALL

EFFECTIVE 10/10/18 **DATE** 10/10/18

RELEASED

AUTH

DATE

D350-748-101

Job Sheet 184478



Part No: D350-748-101

Job Qty: 1 ea

Part Name: FWD Crosstube AS350 / AS355



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/10/18

Job Tracking No:

Due Date: 10/12/18

Created By: Jesse White

Type: SOLD

Description:

Note: DWG REV H IPP Rev:A New Issue 06-07-05 JLM IPP Rev:B Update qty of MS21042L5 06-09-12 KJ VERIFY BY:DD IPP Rev:C Rev B 07-11-15 DD IPP Rev D Combined manufacturing 08.04.02 EC verified by: DD IPP Rev:E 08-06-24 revD as per dwg DD verified by:EC IPP Rev:F 10.08.04 added QSI010 4.3 DD verf:EC IPP REV:G ADD UNDER BEND COMMENT 12-05-28 JLM IPP REV:H 12.11.05 as per dwg D350-748-141G DD verf:JLM IPP REV:I 15.03.19 as per dwg D350-748-141revH dd verf:jlm

Ship Via:

Bill of Materials



Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S117100



Part: D350-748-101

Job No: 184478

Serial No/Batch: S117100

Revision:

Inspector:

Exp Date:

Instructions: 1C STC SH06-27 Issue 2 FAA STC SR02359NY 11/03/04, EASA S

Eng test
RD 18-748-01
10/10/30

SCRAP
P.T.O.

POSITIVE RECALL
EFFECTIVE _____
AUTH _____
RELEASED _____
DATE _____

h.i.o

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		10/12/18	0.00	0.00	Start Up Crosstubes-1		DPZ
110	CNC Bend Skid tubes	1 pcs		10/12/18	0.00	2.86	CNC Bend Skid tube		DPZ
120	Crosstubes	1 pcs		10/12/18	0.00	1.94	Crosstubes-2		DPZ
125	Outsource	1 pcs		10/12/18			MEI001-VC	3	J
126	Packaging	1 pcs		10/12/18	0.00	0.00	Packaging2		DPZ OCT 12 2018
127	QC	1 pcs		10/12/18	0.00	0.00	QC15		38
128	Crosstubes	1 pcs		10/12/18	0.00	1.94	Crosstubes-2		DPZ 9-89
130	Crosstubes	1 pcs		10/12/18	0.00	1.94	Crosstubes-2		DPZ DAS
140	QC	1 pcs		10/12/18	0.00	0.00	QC5		38
150	Outsource	1 pcs		10/12/18			CAD002-VC	8	9-89
160	Packaging	1 pcs		10/12/18	0.00	0.00	Packaging2		DPZ OCT 2 6 2018
170	QC	1 pcs		10/12/18	0.00	0.00	QC6		38
174	Outsource	1 pcs		10/12/18			SKY002-VC		DPZ 9-89
176	Packaging	1 pcs		10/12/18	0.00	0.00	Packaging2		DPZ OCT 3 0 2018
178	QC	1 pcs		10/12/18	0.00	0.00	QC5		
180	SprayPaint	1 pcs		10/12/18	0.00	0.97	Spray Paint		N/A-Eng kit
190	QC	1 pcs		10/12/18	0.00	0.00	QC14		
200	Crosstubes	1 pcs		10/12/18	0.00	1.94	Crosstubes-2		DPZ 10/10/18
210	QC	1 pcs		10/12/18	0.00	0.00	QC5		
220	Packaging	1 pcs		10/12/18	0.00	0.00	Packaging1-3		
230	QC	1 pcs		10/12/18	0.00	0.00	QC4		
240	Packaging	1 pcs		10/12/18	0.00	0.00	Packaging3-1		
245	DC	1 pcs		10/12/18	0.00	0.00	DC		
250	QC21-FG	1 Ea		10/12/18	0.00	0.00	QC21		

Part Op 110 - Bend tube as per Dwg D350-748-141 using CNC bender program D350F and Folio FT *****UNDER BEND
 Descriptions: .225" PER SIDE*****USE (4) DT8824 SHIM BLOC TO CHECK STRAIGHTNESS***** OCT 1 0 2018

120 - ****VERIFY CROSSTUBE DIMENSIONS AS PER DWG****

125 - ISSUE P/O TO METCOR: 41305 AFTER BENDING: STRESS RELIEF AT 650° F ± 25° F FOR A MINIMUM OF 2 HRS AIR COOL TO AMBIENT TEMPERATURE note: crosstube made from 4130 seamless steel tube DETAIL C OF C REQUIRED

127 - ****MARK CUT LINES***

128 - CUT TUBE AT HEIGHT ON FAI SHEET VERF HEIGHT 23.5 BY QC 15 LEVEL INSPECTOR
 VERF TWIST 0.246 BY QC15 LEVEL INSPECTOR

130 - 2- Drill Tube as per Dwg D350-748-141 Using DT8876 A,B & C Drill Jigs, Set-up drill table as per QSI 010 3- Deburr 4- Engrave Part # and Batch # as per Dwg D350-748-141 5- Remove all marks from tube within limits of D350-748-141 6- Apply a light coat of LPS3 on the interior of tube Batch:

140 - CHECK 10 DEG HOLES WITH DT8876E (EUROCOPTER CLAMP) OCT 1 8 2018

150 - Issue P/O: 41324 Stress relief at 375degree for 5hrs Magnetic Particle Inspect per ASTM E1444 Cad Plate per AMS-QQ-P-416B, Class 1, Type 2 Embrittle relief at 375 degree for 8 hrs, Chromate Treat C of C req'd

160 - Ensure certificate of conformity is attached

174 - ISSUE P/O TO SKYSERVICE: 200-11475

180 - 1-Prime inside and out crosstube as per QSI 005 4.2 2-Paint Outside of Tube as per Dart QSI 005 4.2

190 - Then,Wrap in plastic bag to protect from scratches

200 - INSTALL GROUND WIRE INSERT, THEN INSERT SCREW AND WASHER 2-Install supports with Proseal 890 per D350-748-141 and QSI 015 EXP: 3-Install supports clamps Using Dt8876 as per Dwg D350-748-141,Torque to 60-80 IN-LBS. ***RE-CHECK TORCQUE ON CLAMP AFTER PROSEAL HAS CURED FOR 72HOURS AS PER DWG.***

240 - Identify and pack for shipping as per PPP D350-748-101

245 - Photocopy bluefile & type labels per PPPD350-748-101 CHG003

1895 14. 100

25

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25

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1895 14. 100

1895 14. 100

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1895 14. 100

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D350-748-141TRN	Crosstube Turning Detail	1 Ea (1 ea)	90-Start up Operation	
ALS4-1032-225	Rivnut	1 Ea (1 ea)	200-Crosstubes	
D3502-1	Support	2 Ea (2 ea)	200-Crosstubes	
D5123-7	Clamp Cushion	2 Ea (2 ea)	200-Crosstubes	
MS21920-20	Clamp	2 Ea (2 ea)	200-Crosstubes	
MS27039-1-10	Screw	1 Ea (1 ea)	200-Crosstubes	
NAS1149D0363J	Washer	1 Ea (1 ea)	200-Crosstubes	
AN4-41A	Bolt	8 Ea (8 ea)	220-Packaging	
AN4-6A	Bolt	16 Ea (16 ea)	220-Packaging	
AN5-32A	Bolt	4 Ea (4 ea)	220-Packaging	
D3500-1	Saddle	4 Ea (4 ea)	220-Packaging	
D3501-1	Bushing	16 Ea (16 ea)	220-Packaging	
MS21042L4	Nut	24 Ea (24 ea)	220-Packaging	
MS21042L5	Nut	4 Ea (4 ea)	220-Packaging	
NAS1149D0463J	Washer	32 Ea (32 ea)	220-Packaging	
NAS1149D0563J	Washer	8 Ea (8 ea)	220-Packaging	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D350-748-141TRN	1	6	0
200-Crosstubes	ALS4-1032-225	1	1,843	0
	D3502-1	2	38	0
	D5123-7	2	301	0
	MS21920-20	2	200	0
	MS27039-1-10	1	204	0
	NAS1149D0363J	1	1,829	0
220-Packaging	AN4-41A	8	567	0
	AN4-6A	16	1,198	0
	AN5-32A	4	354	0
	D3500-1	4	103	0
	D3501-1	16	547	0
	MS21042L4	24	4,639	0
	MS21042L5	4	733	0
	NAS1149D0463J	32	5,614	0
	NAS1149D0563J	8	1,414	0

Part Specifications

Specifications could not be found.

Plex 10/10/18 12:54 PM dart.white.jesse

Item	Qty	Part Number	Description
	-141		
1	X	D350-748-141	CROSSTUBE ASSEMBLY (AS 350/355 HI FWD)
2	1	D6015-125	CROSSTUBE (OR D6017-115)
3	2	D3502-1	SUPPORT
4	2	D5123-7	CLAMP CUSHION
5	1	AELS-1032-225	INSERT
6	1	NAS1149D0363J	WASHER (OR AN960JD10)
7	2	MS21920-20	CLAMP (OR MS21920-21/-22, PER DART SPEC. M-MS21920-20/-21/-22)
8	1	MS27039-1-10	SCREW
9	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6015-125 OR D6017-115
FINISHED LENGTH AFTER TURNING = 112.270±0.06 (AFTER BENDING/TRIMMING = 110.27 REF)
- 2) FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2
CADMIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCE: PER DART QSI 018 UNLESS OTHERWISE NOTED.
WALL THICKNESS ECCENTRICITY PER DART QSI 038 7.2
MIN. ALLOWABLE WALL IS -0.020 FROM NOMINAL
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: DART PART NUMBER "D350-748-141" AND BATCH NUMBER ON INSIDE OF CUFF
PER DART QSI 044 6.4 (VIBRATING STYLUS)
- 7) WEIGHT: 30.45 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE, EXCEPT FOR Ø0.297 HOLE.
- 9) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO CRACKING/CHIPPING/GROOVES.

TURNING

- 10) BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH. NOTE: ALL HOLES ARE DRILLED AFTER BENDING.
- 11) HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS2759/1E AFTER TURNING. ACCEPTABLE TO VERIFY TENSILE STRENGTH BY HARDNESS TEST PER ASTM E18 TO 40-45 HRC.

BENDING

- 12) ALL DIMENSIONS FOR BENT TUBE ARE POST STRESS RELIEF
- 13) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES PER SIDE. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D. ON TOP HALF OF BEND, AND 8% ON BOTTOM HALF OF BEND.
- 14) MAX AMPLITUDE OF RIBBLING ALONG BENT PORTION OF THE TUBE IS 0.030 (ZN A1-3)
- 15) AFTER BENDING, STRESS RELIEVE TUBE AT 650°F ±0.25°F FOR A MINIMUM OF 2 HRS AND ALLOW TO COOL TO AMBIENT TEMPERATURE (REF AMS2759/1E).
- 16) MAX TWIST AFTER STRESS RELIEF: WITH XTUBE LAYED FLAT ON SURFACE, THE DIFFERENCE BETWEEN CUFF HEIGHTS FROM THE SURFACE MAY BE NO LARGER THAN 0.38 (ZN C1-3).

ASSEMBLY

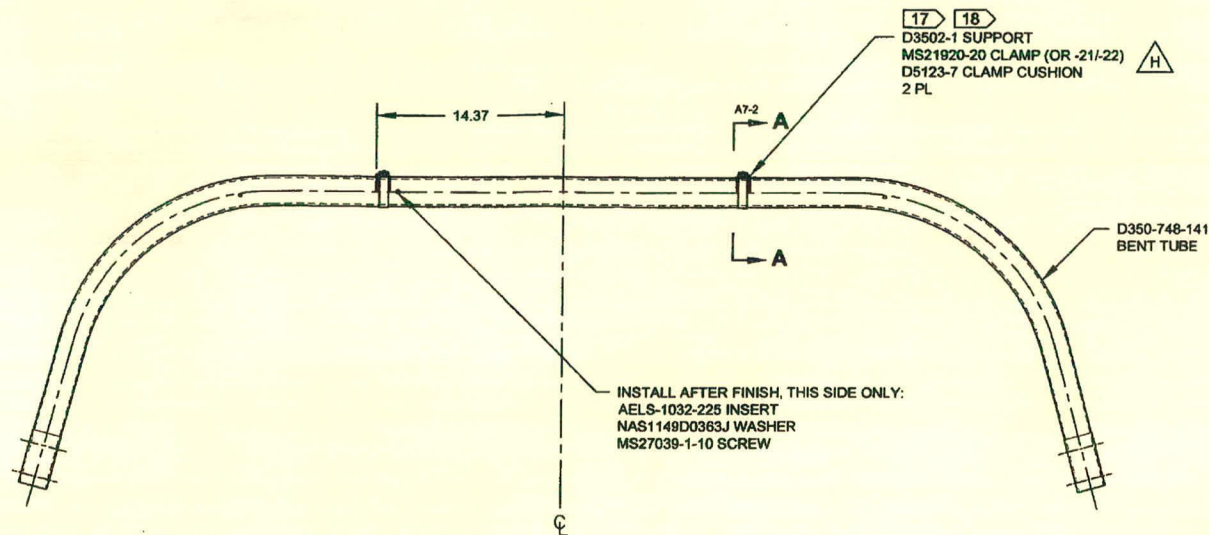
- 17) TO INSTALL D3502-1 SUPPORT: ABRABE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.02" TO 0.05" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- 18) TORQUE CLAMPS 60 TO 80 IN.-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.

RELEASED

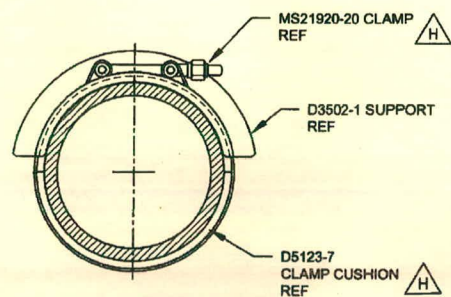
2015 MAR 18

9 EN 15-577

H	D5123-7 WAS D3585-063-395, MS21920-20 WAS -22, ALLOWABLE CRUSHING NOW 8% WAS 7%	CP	15.02.25
G	RMV ABRASION STRIP, SUPPORT NOW W/ PROSEAL & CUSHION, ADD STRESS RELIEF, LONGER CUFF, NOW TRIMD AFTER BEND, ADD WALL DIMS & UPDATE TOL.	CP	12.09.12
F	ADD HRC TEST OPTION (B8-1) PER PAR 08-040, ADD TWIST LIMIT (A8-1, C1-3), ADD D6015-125 OPTION (C8-1), STOCK DIM NOW MACHINED (D1-4)	CP	10.11.23
E	REVISE GENERAL NOTES; UPDATE TO CURRENT ADD STANDARDS; RELOCATED FLAG #6 PER PAR 08-046 (ZN A6-3); TOLERANCES (ZN C6-3, D1-3)	RF	09.09.30
D	MAG. PARTICLE AND CAD PLATE AS MFD.	CP	06.10.31
C	ADD CAD PLATING	CP	06.08.14
B	ADD D6017-115 & PRIME AND PAINT	CP	06.06.30
A	NEW ISSUE	CP	06.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED	AS		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	15.02.25		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWING NO.		REV. H	
D350-748-141		SHEET 1 OF 4	
TITLE		SCALE	
CROSSTUBE (AS 350/355 HI FWD)		NTS	
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**D350-748-141
ASSEMBLY DETAIL**

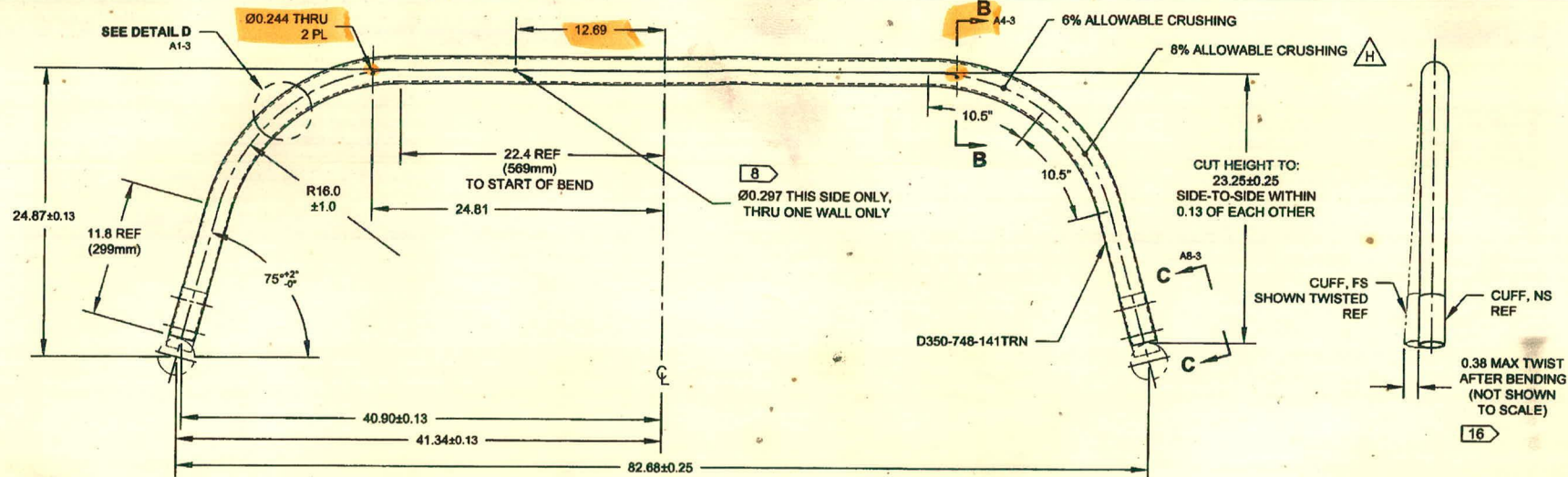


SECTION A-A D4-2
SCALE 6X

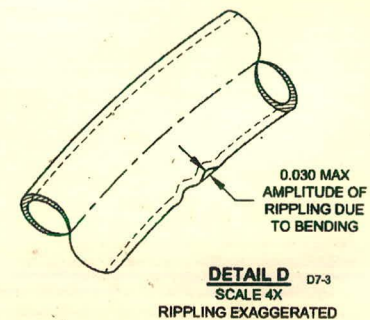
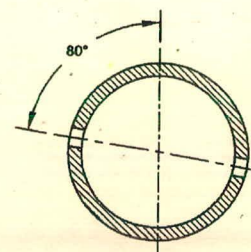
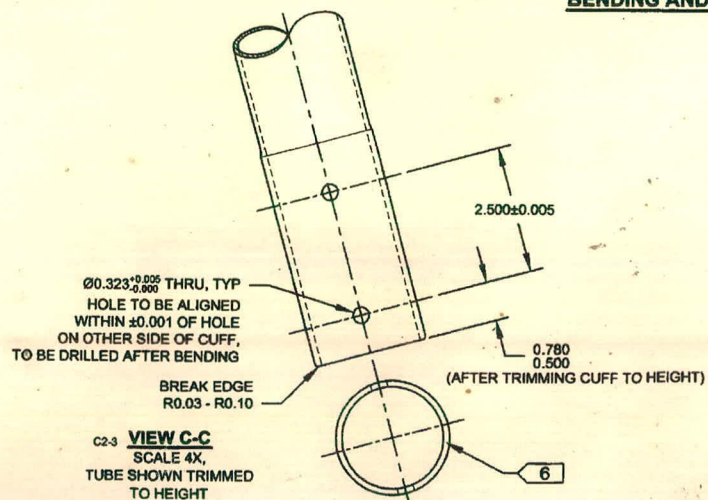
RELEASED

2015 MAR 18

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. H
MFG. APPR.		D350-748-141	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE (AS 350/355 HI FWD)	NTS
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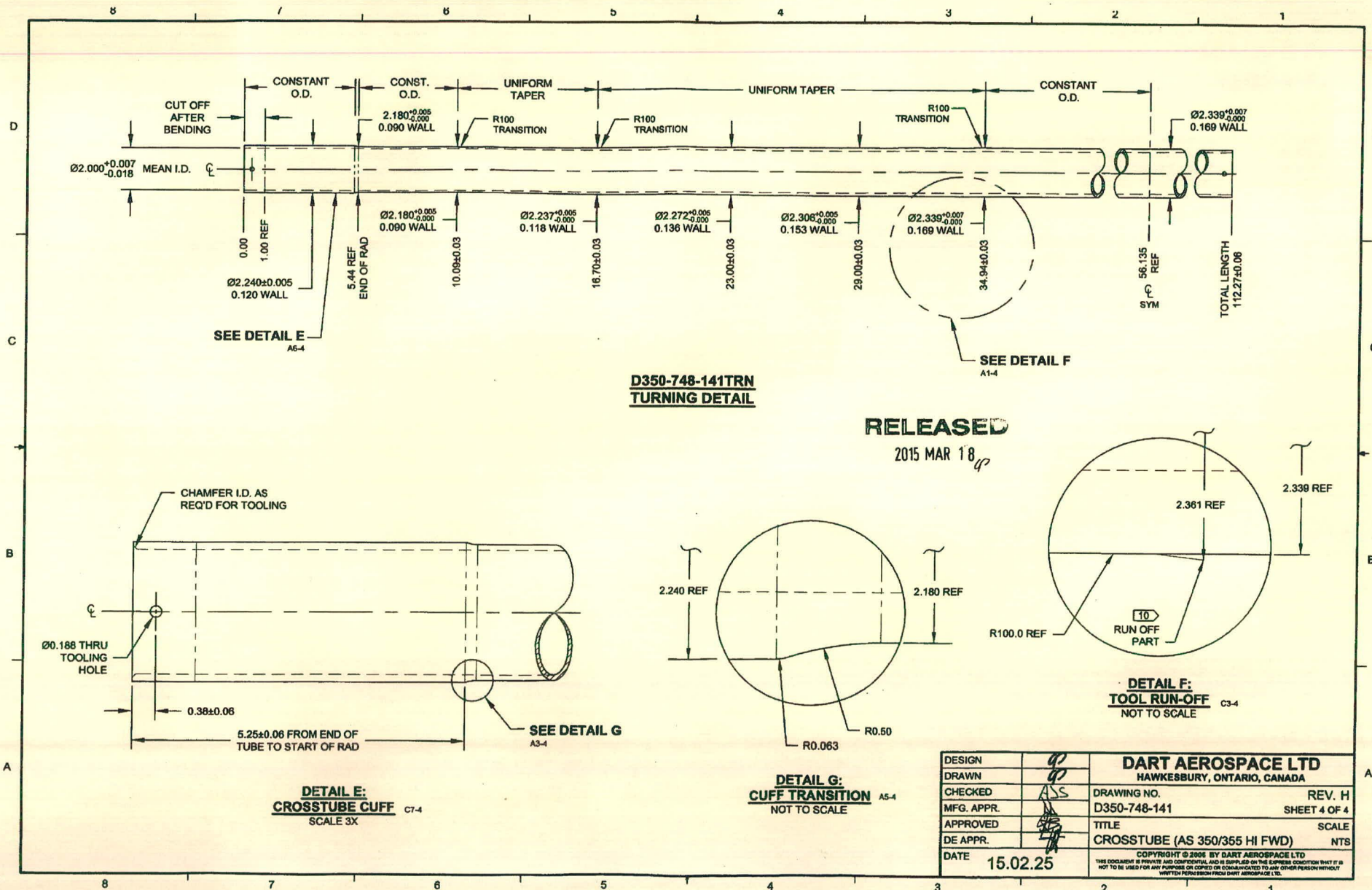


D350-748-141
BENDING AND DRILLING DETAIL 13



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2015 MAR 18

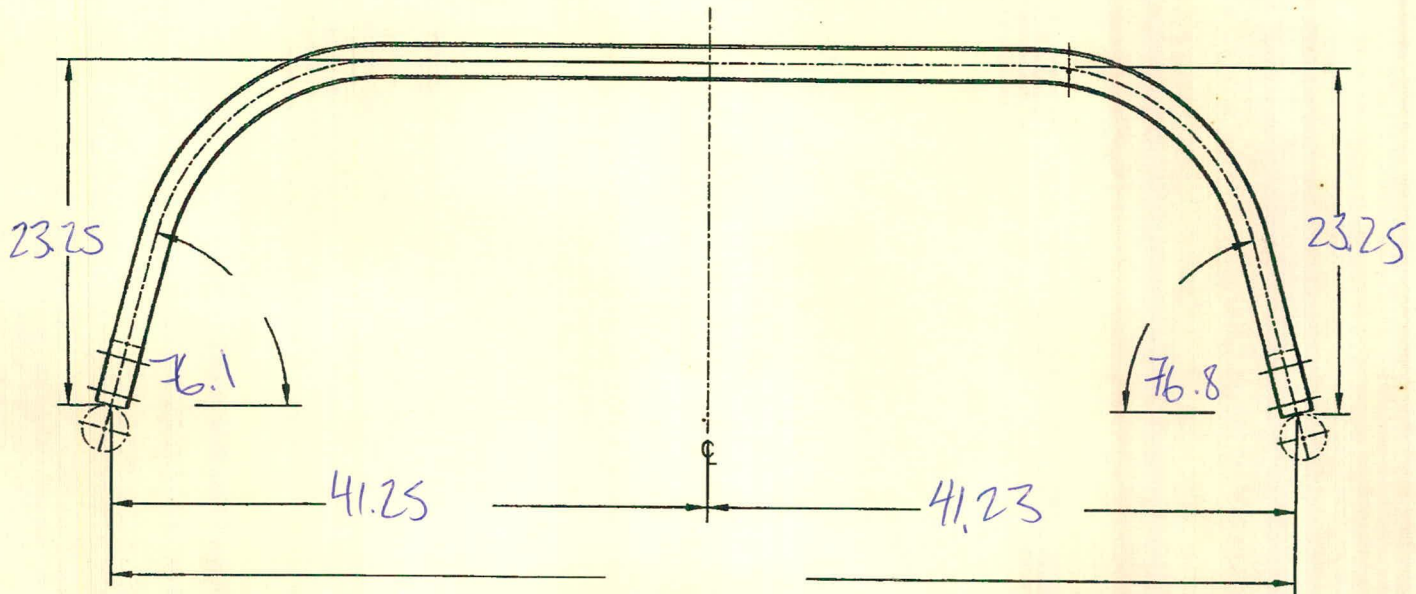
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D350-748-141	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE (AS 350/355 HI FWD)	NTS
DATE	15.02.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



Before De-stress

DART AEROSPACE LTD		Work Order:	
Description: Crosstube High Fwd (AS350/355)		Part Number:	D350-748-101
Inspection Dwg: D350-748-141 Rev: H			Page 1 of 1

Required Dimension	Min	Max
Height	23.00	23.50
1/2 Span	40.77	41.03
Angle	75	77
Total Span	81.55	82.05
Bending Passes	7	--
Crushing	--	8%
Twist	--	0.38



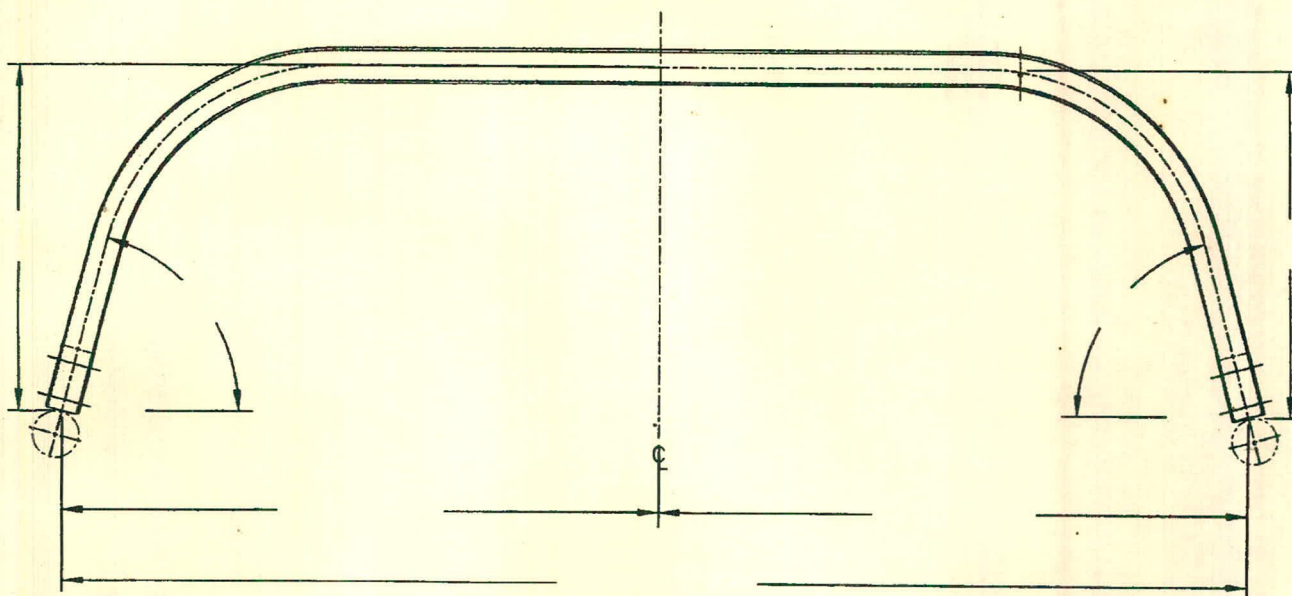
	Side A	Side B
Bending Passes		
Crushing		
Comments		

QC15 Inspection	
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	10.08.23	Dwg Rev updated	KJ	
C	11.11.07	Dwg Rev updated	KJ	
D	12.04.16	Added bending, crushing & twist dimensions	KJ	
E	13.02.27	Dwg Rev updated	KJ	
F	14.02.13	Crushing & twist dimensions revised	KJ	
G	14.11.10	Height dimension revised	KJ	
H	15.04.14	Dwg Rev updated	KJ	
I	15.09.09	Crushing dimension revised	KJ	

DART AEROSPACE LTD		Work Order:
Description: Crosstube High Fwd (AS350/355)		Part Number: D350-748-101
Inspection Dwg: D350-748-141	Rev: H	Page 1 of 1

Required Dimension	Min	Max
Height	23.00	23.50
1/2 Span	40.77	41.03
Angle	75	77
Total Span	81.55	82.05
Bending Passes	7	--
Crushing	--	8%
Twist	--	0.38



	Side A	Side B
Bending Passes		
Crushing		
Comments		

QC15 Inspection	
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	10.08.23	Dwg Rev updated	KJ	
C	11.11.07	Dwg Rev updated	KJ	
D	12.04.16	Added bending, crushing & twist dimensions	KJ	
E	13.02.27	Dwg Rev updated	KJ	
F	14.02.13	Crushing & twist dimensions revised	KJ	
G	14.11.10	Height dimension revised	KJ	
H	15.04.14	Dwg Rev updated	KJ	
I	15.09.09	Crushing dimension revised	KJ	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041305**

Supplier: MEI001-VC
Metcor Inc.
560 Boul. Arthur Sauve
Saint-Eustache
QC
J7R 5A8 Canada
Phone: 450 473 1884
Fax: 450 491 5498

PO No: PO041305

PO Date: 10/10/18

Due Date: 10/11/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

E-MAILED

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	184478	D350-748-101	FWD Crosstube AS350 / AS355 ISSUE P/O TO METCOR: AFTER BENDING: STRESS RELIEF AT 650° F ± 25° F FOR A MINIMUM OF 2 HRS AIR COOL TO AMBIENT TEMPERATURE note: crosstube made from 4130 seamless steel tube DETAIL C OF C REQUIRED	Firmed	-	10/11/18	1 pcs	0 pcs	1 pcs	\$205.00/pcs	\$205.00
	184479		1 X OCT 12 2018	Firmed	-	10/11/18	1 pcs	0 pcs	1 pcs	\$205.00/pcs	\$205.00
	184476		1 X OCT 12 2018	Firmed	-	10/11/18	1 pcs	0 pcs	1 pcs	\$205.00/pcs	\$205.00
Sub Total:							3	0	3		\$615.00

Grand Total: \$615.00

DAS
38
9-89

CL



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO041305

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 10/10/18 2:33 PM dart.lavoie.chantal



METCOR INC.

560 BOUL. ARTHUR-SAUVÉ
ST-EUSTACHE, QC J7R 5A8
Tel: 450-473-1884 / Fax: 450-491-5498

Reçu de livraison

Delivery Receipt

BON DE TRAVAIL Order	EXPÉDITEUR Shipper ID	BON D'EXPÉDITION Shipper
331059	1	131541

EXPÉDITION COMPLÈTE / Shipped Complete

CLIENT /Customer 215

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053



LIVRÉ À /Shipped To

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053

COMMANDE DU CLIENT Customer PO	BON DE LIVRAISON DU CLIENT Customer Shipper No.	TYPE DE MATÉRIEL Material Type	DATE DE LA COMMANDE Order Date	TRANSPORTEUR Carrier
PO041305		Steel	2018/10/10	client

QUANTITÉ Quantity	No. PIÈCE / Part No.	NOM DE LA PIÈCE / Part Name	DESCRIPTION DE LA PIÈCE Part Description	POIDS Weight
3	D350-748-101	CROSSTUBE	(3) D350-748-101 JOB 184478,184479,184476,	93,
			1 NIL	

TYPE DE CONTENEUR Container Type	# DE CONTENEURS # Of Containers	COMMENTAIRES CONTENEUR Container Comments
NIL	1	

CERTIFICAT

EMPAQUETAGE Packing	
-------------------------------	--

QUANTITÉ EXPÉDIÉE / Quantity Shipped : 3

POIDS EXPÉDIÉ / Weight Shipped : 93,00

QUANTITÉ RESTANTE / Quantity Remaining : 0

POIDS RESTANT / Weight Remaining : 0,00

CERTIFICAT

APPROUVÉ
ACCEPTE

QUANTITÉ EXPÉDIÉE / Quantity Shipped: 3

POIDS EXPÉDIÉ / Weight Shipped : 93,00

Signature:

Date:

EXPÉDIÉ LE / Shipped On : 2018/10/11

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité

Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
331059	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

1

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
PO041305	N/A	Steel		

SPÉCIFICATIONS DU PROCÉDÉ

processing specifications

STRESS REL

SAE AMS 2759/1 REV.F

EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
Visual			

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
3	93	D350-748-101 CROSSTUBE (3) D350-748-101 JOB 184478, 184479, 184476. 1 NIL

COMMENTAIRES / comments

APPROUVÉ par / Approved by:

DATE: 2018-10-11

Pierre Piché
Chief Inspector



DAS
38
9-89

APPROUVÉ

METCOR INC.

500 BOUT. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A5

Tél : 450-473-1884

Télécopieur / Fax administration : 450-491-2498

Télécopieur / Fax production : 450-491-2424

Certificat de Conformité
Certificate of Compliance

CHARGEMENT load	BON DE TRAVAIL order
1	331050

CLIENT / customer : 218
DART AEROSPACE
1370 ABERDEEN
HAWKESBURY

ON K8A 1K7

LIVRÉ À / shipped to:
DART AEROSPACE
1370 ABERDEEN
HAWKESBURY

ON K8A 1K7

COMMANDE DU CLIENT customer po	CLASSIFICATION PIÈCE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
PO041305	N/A	Steel		
STRESS REL SAE AMS 2750/1 REV.F EXIGENCE / requirement : SPÉCIFICATIONS / specified TESTS EXÉCUTÉS / performed : RÉSULTATS DE TESTS / results				
Visual				

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
3	83	1 NIL JOB 184478, 184479, 184478 (3) D350-748-101 CROSTUBE D350-748-101

COMMENTAIRES / comments

APPROUVÉ par / approved by:

DATE: 2018-10-11

Chief Inspector
8

APPROUVÉ

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>184478</u> Part No. <u>D350-748-101</u> NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Large Fab ☐	Composite ☐	Supplier ☐																																																																					
Date : <u>18-10-12</u>		Step #: <u>127</u>		QTY Effective : <u>1</u>			MRB (QSI042) Approval																																																																
Description Work Order Deviation				Disposition			Completed By																																																																
Rippling is .030" deep. Drawing allows a maximum of .030" Cancelled							Lead hand / Supervisor Approval Verification																																																																
							QC / QA Coordinator Approval																																																																
Root Cause <table style="width:100%; border: none;"> <tr><td style="border: none;">Environment ☐</td><td style="border: none;">No Re-verification ☐</td></tr> <tr><td style="border: none;">Design ☐</td><td style="border: none;">Operator ☐</td></tr> <tr><td style="border: none;">Doc/Data ☐</td><td style="border: none;">Offset/Setup ☐</td></tr> <tr><td style="border: none;">Equip/Tooling ☐</td><td style="border: none;">Supplier ☐</td></tr> <tr><td style="border: none;">Handling/Pre ☐</td><td style="border: none;">Training ☐</td></tr> <tr><td style="border: none;">Material ☐</td><td style="border: none;">Use for Testing ☐</td></tr> <tr><td style="border: none;">Internal Transport ☐</td><td style="border: none;">Poor Information ☐</td></tr> <tr><td style="border: none;">Tribal Knowledge ☐</td><td style="border: none;">Rushing ☐</td></tr> <tr><td style="border: none;">LOA ☐</td><td style="border: none;">Product Improvement ☐</td></tr> <tr><td style="border: none;">Substation ☐</td><td style="border: none;">Process Improvement ☐</td></tr> <tr><td style="border: none;">Past Expiry Date ☐</td><td style="border: none;">Manufacturing Process ☐</td></tr> <tr><td style="border: none;">Misidentified ☐</td><td style="border: none;">Past Due ☐</td></tr> </table>		Environment ☐	No Re-verification ☐	Design ☐	Operator ☐	Doc/Data ☐	Offset/Setup ☐	Equip/Tooling ☐	Supplier ☐	Handling/Pre ☐	Training ☐	Material ☐	Use for Testing ☐	Internal Transport ☐	Poor Information ☐	Tribal Knowledge ☐	Rushing ☐	LOA ☐	Product Improvement ☐	Substation ☐	Process Improvement ☐	Past Expiry Date ☐	Manufacturing Process ☐	Misidentified ☐	Past Due ☐	FAULT CATEGORY <table style="width:100%; border: none;"> <tr> <td style="border: none;">Pressure/Forced ☐</td> <td style="border: none;">Temperature/Cure ☐</td> <td style="border: none;">Power Loss/Surge ☐</td> <td style="border: none;">Positioned Wrong ☐</td> </tr> <tr> <td style="border: none;">Bending ☐</td> <td style="border: none;">Set-up ☐</td> <td style="border: none;">Folio/Program ☐</td> <td style="border: none;">Outside Dimensions ☐</td> </tr> <tr> <td style="border: none;">Centre Not Concentric ☐</td> <td style="border: none;">BOM/Route ☐</td> <td style="border: none;">Grain ☐</td> <td style="border: none;">Over/Under tolerance ☐</td> </tr> <tr> <td style="border: none;">Cracks ☐</td> <td style="border: none;">Broken/Damage/Defect ☐</td> <td style="border: none;">Weld ☐</td> <td style="border: none;">Part Incorrect ☐</td> </tr> <tr> <td style="border: none;">Crimp/Kink/Ripple/Wave ☐</td> <td style="border: none;">Inspection Incomplete/Unqualified ☐</td> <td style="border: none;">Wrong Stock Pulled ☐</td> <td style="border: none;">Part Lost/Missing ☐</td> </tr> <tr> <td style="border: none;">Cuffs ☐</td> <td style="border: none;">Contamination ☐</td> <td style="border: none;">Out of Sequence ☐</td> <td style="border: none;">Part Moved ☐</td> </tr> <tr> <td style="border: none;">Crushing ☐</td> <td style="border: none;">Countersink ☐</td> <td style="border: none;">Off-set ☐</td> <td style="border: none;">Drawing ☐</td> </tr> <tr> <td style="border: none;">Heat Treat ☐</td> <td style="border: none;">Cut Too Short ☐</td> <td style="border: none;">Mislabeled ☐</td> <td style="border: none;">Finish ☐</td> </tr> <tr> <td style="border: none;">Wave/Twist in Tube ☐</td> <td style="border: none;">Instructions Incomplete/Unclear ☐</td> <td style="border: none;">Fit/Function ☐</td> <td style="border: none;">Misread ☐</td> </tr> <tr> <td style="border: none;">Marks/Chatter ☐</td> <td style="border: none;">Drill Holes ☐</td> <td style="border: none;">Misaligned/off center ☐</td> <td style="border: none;">Turning Sequence ☐</td> </tr> </table>						Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
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OTHER : _____																																																																							



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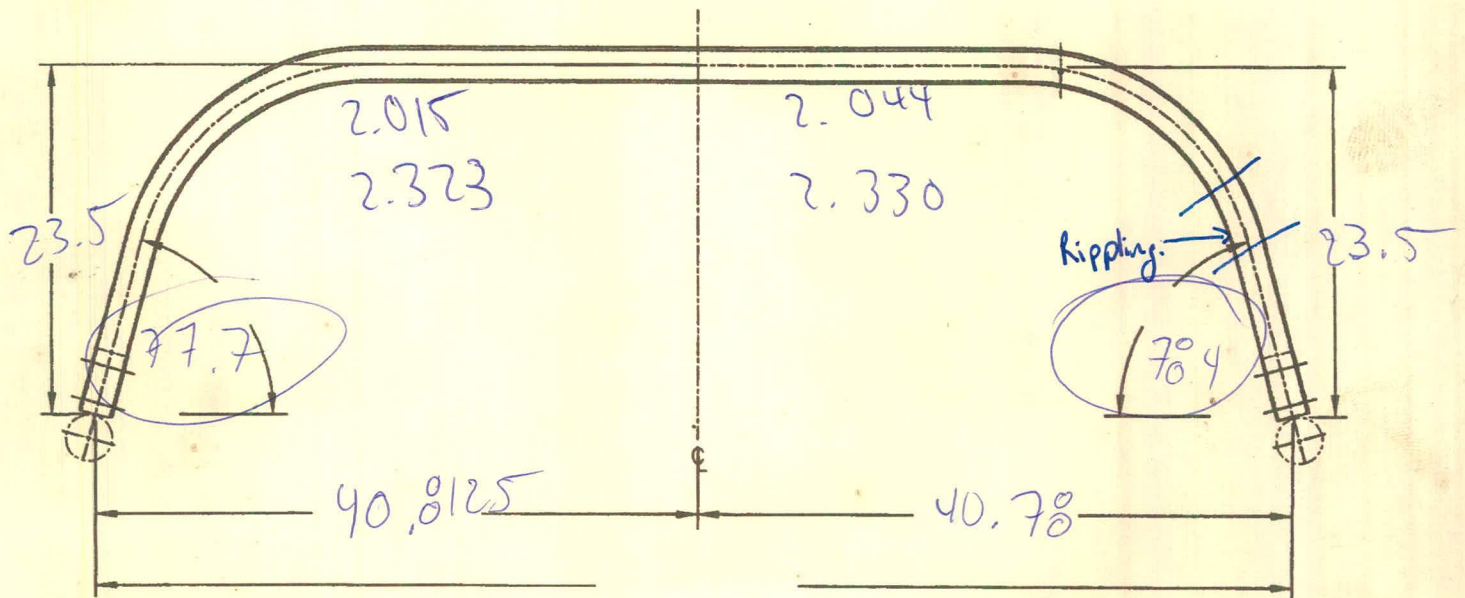
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DART AEROSPACE		Order:	189478
Description: Crosstube High Fwd (8981055)		Part Number:	D350-748-101
Inspection Dwg: D350-748-141	Rev: H	Page 1 of 1	

Required Dimension	Min	Max
Height	23.00	23.50
1/2 Span	40.77	41.03
Angle	75	77
Total Span	81.55	82.05
Bending Passes	7	--
Crushing	--	8%
Twist	--	0.38



	Side A	Side B
Bending Passes		
Crushing	2.1 %	5.2 %
Comments		
Rippling is at 80mm Deep on one side		

QC15 Inspection	
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	10.08.23	Dwg Rev updated	KJ	
C	11.11.07	Dwg Rev updated	KJ	
D	12.04.16	Added bending, crushing & twist dimensions	KJ	
E	13.02.27	Dwg Rev updated	KJ	
F	14.02.13	Crushing & twist dimensions revised	KJ	
G	14.11.10	Height dimension revised	KJ	
H	15.04.14	Dwg Rev updated	KJ	
I	15.09.09	Crushing dimension revised	KJ	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

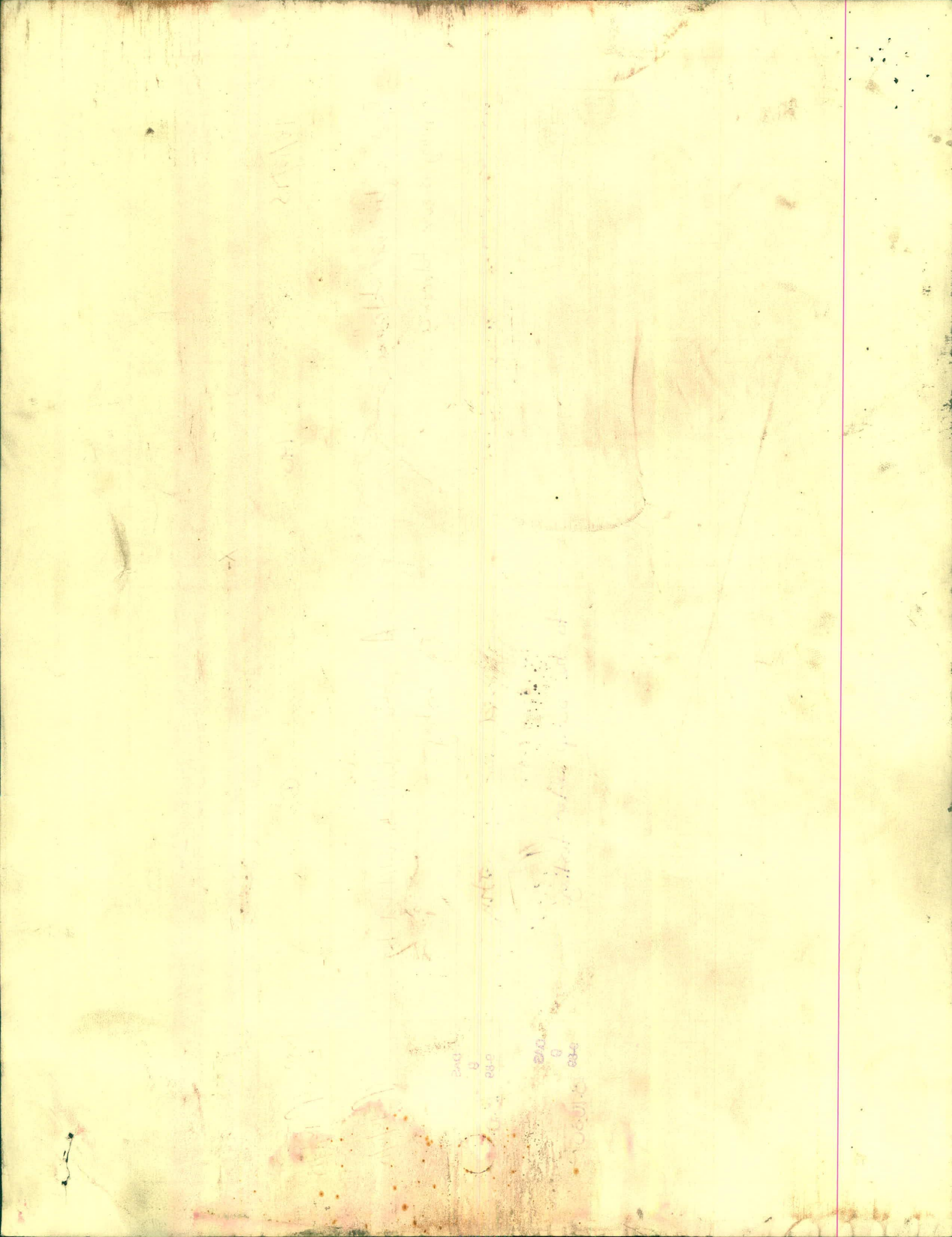
Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☒ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
----------------------------------	--	---	--	--	--

Date : 18/10/15	Sequence #: 140	QTY Affected : ①	MRB (QSI042) INSP 12 18/10/15
-----------------	-----------------	------------------	----------------------------------

Description Work Order Deviation	Disposition	Completed By
Band angles over tolerance. Rippling is over tolerance. Diameter at max crushing = 1.955"	Acceptable. will be validated by Eng. testing. ↳ Used for Eng testing RD18-748-01 to be scrap after testing. 18/10/30	18/10/15
		Lead hand / Supervisor DAS 9 9-89 18.10.30
		QC / QA Coordinator DAS 9 9-89 18.10.30

Root Cause	FAULT CATEGORY		
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☒ Product Improvement ☐ Process Improvement ☐ Human Factors ☐	☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☒ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled	☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up
Other/Details: _____			





Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041374**

Supplier: CAD002-VC
Cadorath Coating
2150 Logan Ave.
Winnipeg
MB
R2R 0J2 Canada
Phone: 204 633 9420
Fax: 204 633 8033

PO No: PO041374
PO Date: 10/18/18
Due Date: 10/31/18

Purchase Order
Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pynt Terms: Net 30

Freight Terms:

Special Comments:

E-MAILED
OCT 19 2018

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	184476	D350-748-101	FWD Crosstube AS350 / AS355 : TC STC SH06-27 Issue 2, FAA STC SR02359NY 11/03/04, EASA STC EASA.10016903 Revision 2 10/09/03, BRAZIL 2009S04-04 09/04/06 Issue P/O: Stress relief at 375degree for 5hrs Magnetic Particle Inspect per ASTM E1444 Cad Plate per AMS-QQ-P-416B, Class 1, Type 2 Embrittle relief at 375 defree for 8 hrs, Chromate Treat C of C req'd serial # S117106	Firmed	-	10/31/18	1 pcs	0 pcs	1 pcs	\$805.00/pcs	\$805.00
	184479		serial # S117081	Firmed		10/31/18	1 pcs	0 pcs	1 pcs	\$805.00/pcs	\$805.00
	184478		serial # S117100	Firmed		10/31/18	1 pcs	0 pcs	1 pcs	\$805.00/pcs	\$805.00
Sub Total:							3	0	3		\$2,415.00



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041374**

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
2	184480	D350-748-201	Aft Crosstube AS350 / AS355 : TC STC SH06-27 Issue 2, FAA STC SR02359NY 11/03/04, EASA STC EASA.10016903 Revision 2 10/09/03, BRAZIL 2009S04-04 09/04/06 Issue P/O: Stress relief at 375degree for 5hrs Magnetic Particle Inspect per ASTM E1444 Cad Plate per AMS-QQ-P-416B, Class 1, Type 2 Embrittle relief at 375 defree for 8 hrs, Chromate Treat C of C req'd serial # S117528	Firmed	-	10/31/18	1 pcs	0 pcs	1 pcs	\$805.00/pcs	\$805.00
	184483		serial # S117537	Firmed		10/31/18	1 pcs	0 pcs	1 pcs	\$805.00/pcs	\$805.00
Sub Total:							2	0	2		\$1,610.00

Grand Total: \$4,025.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retension of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 10/18/18 10:24 AM dart.lavoie.chantal

Packing Slip



Cadorath Coating

2150 Logan Avenue, Winnipeg, Manitoba R2R-0J2

Phone: (204) 633-9420 Fax: (204) 633-8033

INVOICE NUMBER:

S98011

Sold To:

Dart Aerospace Ltd.
1270 Aberdeen St.

Hawksbury, ON K6A 1K7

ShipTo:

Net 2% Interest Per Month charged on Overdue Accounts.

Any claims for shortages, overcharges, or damaged goods must be made within seven (7) days from receipt of goods.

Customer Order #: PO041374

DateReceived: Oct-19-2018

Terms:

NET 30 DAYS

G.S.T. #:

10071 6547 RT0001

Ship Via:

Ship Date:

Oct-25-2018

Item # Qty P/N & Description

1	1 EA	CROSSTUBE ✓ P/N d350-748-101 ✓	S/N S117106 ✓ W/O 187621
2	1 EA	CROSSTUBE ✓ P/N d350-748-101 ✓	S/N S117081 ✓ W/O 187622
3	1 EA	CROSSTUBE ✓ P/N d350-748-101 ✓	S/N S117100 ✓ W/O 187623
4	1 EA	CROSSTUBE ✓ P/N D350-748-201 ✓	S/N S117528 ✓ W/O 187624
5	1 EA	CROSSTUBE ✓ P/N D350-748-201 ✓	S/N S117537 ✓ W/O 187625

**CERTIFICATE OF
CONFORMANCE**

**CADORATH PLATING CO. LTD.
2150 LOGAN AVENUE
WINNIPEG, MANITOBA R2J-0J1**

DATE: Oct-25-2018

CONSIGNEE TO: Dart Aerospace Ltd.
1270 Aberdeen St.
Hawksbury, ON K6A 1K7

W/O #: 187623

INVOICE #: 98011

**CONTRACT OR
PURCHASE ORDER #** PO041374 ✓

DESCRIPTION: CROSSTUBE

QTY ✓ 1

P/N # d350-748-101 ✓

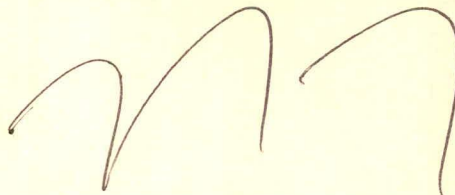
S/N # S117100 ✓

STRESS RELIEF BAKE HEAT CHART # 18-980. MPI IAW ASTM-E-1444. CADMIUM PLATE IAW AMS-QQ-P-416C TYPE 2 YELLOW CLASS 1. FINAL MPI IAW ASTM-E-1444. EMBRITTLE RELIEF BAKE HEAT CHART # 18-990.

DAS
38
9-89

CERTIFICATE: I certify that the items indicated here on have been inspected and tested and conform to all specifications and requirements detailed on the contract or purchase order.

Approved Inspector:





Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041475**

Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

PO No: PO041475
PO Date: 10/26/18
Due Date: 10/30/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pynt Terms: Net 30
Freight Terms:
Special Comments:

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	184178	D4464-041	Fuel Tank Assembly : Various STC's ISSUE P/O : LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417 LEVEL 2	Firmed	-	10/30/18	1 pcs	0 pcs	1 pcs	\$156.00/pcs	\$156.00
						1X OCT 30 2018					
2	184697	D212-664-101	Fwd Crosstube - High : TC STC SH01-9 Issue 3, FAA STC SR01298NY 09/01/08, EASA STC EASA.IM.R.S.01304 07/03/06, DGAC MEXICO STC IA-316/2015 15/06/17 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed	-	10/30/18	1 pcs	0 pcs	1 pcs	\$75.00/pcs	\$75.00
						1X OCT 30 2018					
	184695			Firmed	-	10/30/18	1 pcs	0 pcs	1 pcs	\$75.00/pcs	\$75.00
						Sub Total:	2	0	2		\$150.00
3	183769	D212-664-201	Aft Crosstube - High : TC STC SH01-9 Issue 3, FAA STC SR01298NY 09/01/08, EASA STC EASA.IM.R.S.01304 07/03/06, DGAC MEXICO STC IA-316/2015 15/06/17 ***WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Issue P/O: LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417 LEVEL 2	Firmed	-	10/30/18	1 pcs	0 pcs	1 pcs	\$156.00/pcs	\$156.00
						1X OCT 30 2018					
	183770			Firmed	-	10/30/18	1 pcs	0 pcs	1 pcs	\$156.00/pcs	\$156.00
						1X OCT 30 2018					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041475**

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
Sub Total:							2	0	2		\$312.00
4	184479	D350-748-101	FWD Crosstube AS350 / AS355 : TC STC SH06-27 Issue 2, FAA STC SR02359NY 11/03/04, EASA STC EASA.10016903 Revision 2 10/09/03, BRAZIL 2009S04-04 09/04/06 Issue P/O: _____ Stress relief at 375degree for 5hrs Magnetic Particle Inspect per ASTM E1444 Cad Plate per AMS-QQ-P-416B, Class 1, Type 2 Embrittle relief at 375 degree for 8 hrs, Chromate Treat C of C req'd ISSUE P/O TO SKYSERVICE: _____	Firmed -		10/30/18	1 pcs	0 pcs	1 pcs	\$122.7272/pcs	\$122.73
	184476			Firmed -		10/30/18	1 pcs	0 pcs	1 pcs	\$122.7272/pcs	\$122.73
	184478			Firmed -		10/30/18	1 pcs	0 pcs	1 pcs	\$122.7272/pcs	\$122.73
Sub Total:							3	0	3		\$368.18
5	184480	D350-748-201	Aft Crosstube AS350 / AS355 : TC STC SH06-27 Issue 2, FAA STC SR02359NY 11/03/04, EASA STC EASA.10016903 Revision 2 10/09/03, BRAZIL 2009S04-04 09/04/06 ISSUE P/O TO SKYSERVICE: _____	Firmed -		10/30/18	1 pcs	0 pcs	1 pcs	\$122.7272/pcs	\$122.73
	184483			Firmed -		10/30/18	1 pcs	0 pcs	1 pcs	\$122.7272/pcs	\$122.73
Sub Total:							2	0	2		\$245.45
Grand Total:											\$1,231.64



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PURCHASE ORDER PO041475

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 10/29/18 8:56 AM dart.tsimiklis.chrisoula





skyservice Work Order Traveler

Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO37958	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: PO041475
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	

Task: UNSCHEDULED	Sequence: 1
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Work Required:

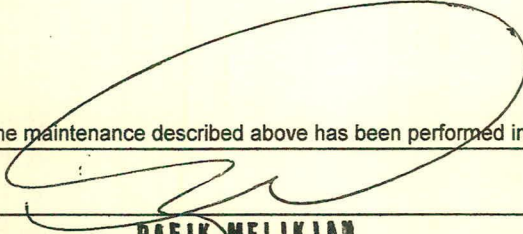
CARRY OUT NDT ON:

- 1 FUEL TANK ASSY, P/N# D4464-041, J/S# 184178 ✓
- 2 FWD CROSSTUBES, P/N# D212-664-101, J/S# 184695, 184697 ✓
- 2 AFT CROSSTUBES, P/N# D212-664-201, J/S# 183770, 183769 ✓
- 3 FWD CROSSTUBES, P/N# D350-748-101, J/S# 184476, 184478, 184479 ✓
- 2 AFT CROSSTUBES, P/N# D350-748-201, J/S# 184480, 184483 ✓

Action Taken:	Date:	Initial/Stamp:
LPI C/O IAW ASTM E-1417 REV. 16 NO CRACK FOUND PEN. ZL-56, MPO13600, CLEANER SKC-S MPO13923, DEV. MPO11715, UV LIGHT M-20142	OCT 26 2018	 

Description	Location	P/N	Qty	Batch	S/N Off	S/N On

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature: 	ACA/SCA Stamp 	Date: OCT 26 2018
Name: RAFIK MELIKIAN		

